

24/02

Work Order ID 66532



Page 1

Friday, February 18, 2011 2:51:41 PM

Item ID: D4149-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Aft

Start Date: 2/18/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4149

B

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

2/21/22 @

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2/20/22

④

120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

408

2/21/22 @

Work Order ID 66532

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Item ID: D4149-041

Accept



Setup Start



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Stop



Item Name: Crosstube Lug Assembly, Aft

Start Date: 2/18/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/22

MF

11-02-22

Picklist Print

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Page 1

Work Order ID: 66532

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft





Start Date: 2/18/2011

Required Date: 2/22/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4149-5  Eyebolt Stud		Manufactured	No			100	Each	5.0000	1	2		2/11/02/22	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST133				5				B66226 (12)	
MS20615-4M18  Rivet		Purchased	No			100	Each	209.0000	3	6		2/11/02/22	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST323				209					
				114808				128					
				115037				81					
D3910-1  Crosstube Lug		Manufactured	No			100	Each	15.0000	1	2		2/11/02/22	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				st507				15					
				59708				1					
				65631				14					
D4091-1  Mounting Lug		Manufactured	No			100	Each	0.0000	1	2		2/11/02/22	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				

B65626 (12)

Picklist Print

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Work Order ID: 66532

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 2/18/2011

Required Date: 2/22/2011

Start Qty: 2.00

Required Qty: 2.00

D4149-1 Manufactured No

100 Each

5.0000

2

4



Crosstube Lug Plate, Aft



ES 11/02/22

Location

Loc Qty

Loc Code

ST123

5

61235 ✓

5

2

~~D4149-3~~

Manufactured No

100 Each

5.0000

1

2



Spacer



ES 11/02/22

Location

Loc Qty

Loc Code

ST123

5

61010

5

B60780 (12)

AN3C12A

Purchased No

100 Each

102.0000

4

8



Bolts



ES 11/02/22

Location

Loc Qty

Loc Code

ST351

102

112314

8

114761

11

116022

2

116289

17

116786 ✓

14

116924

50

2

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 66532

Parent Item: D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 2/18/2011

Required Date: 2/22/2011

Start Qty: 2.00

Required Qty: 2.00

AN4C13A

Purchased

No

100

Each

67.0000

1

2



BOLT



EP 11/02/22

Location

Loc Qty

Loc Code

ST357

67

113359

3

114442

5

114615

2

116191

7

116914

50

2

1

MS21043-3

Purchased

No

100

Each

1,276.000

4

8



Nut



EP 11/02/22

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1200

112314 ✓

1200

2

MS21043-4

Purchased

No

100

Each

963.0000

1

2



Nut



EP 11/02/22

Location

Loc Qty

Loc Code

ST301

963

114523

5

114784

2

115936 ✓

60

116188

596

116549

300

1

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Shop Packet Print

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Picklist Print

Friday, February 18, 2011 2:51:38 PM

Page 4

Work Order ID: 66532



Parent Item: D4149-041



Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 2/18/2011

Required Date: 2/22/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0432R

Purchased

No

100

Each

2,146.000

2

4



Washer

Location

Loc Qty

Loc Code

ST297

2146

114292

36

116304

91

116805

93

116900 ✓

1926



EP 11/02/22

NAS1149C0332R

Purchased

No

100

Each

2,816.000

8

16



Washer

Location

Loc Qty

Loc Code

ST297

2816

115000

125

115698

35

116025

108

116304 ✓

2548

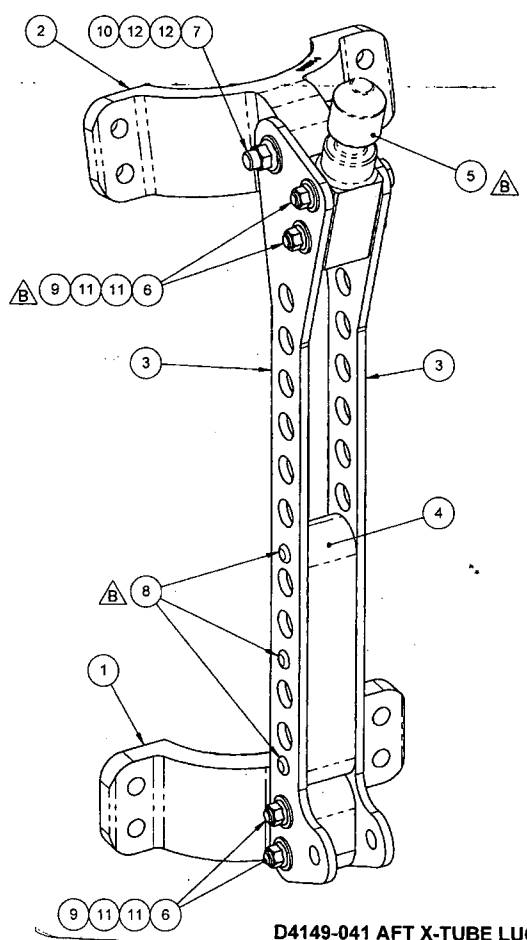


EP 11/02/22

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Shop Packet Print

Page 4



D4149-041 AFT X-TUBE LUG ASSY

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 2.17 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	4	AN3C12A	
7	1	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	4	MS21043-3	NUT
10	1	MS21043-4	NUT
11	8	NAS1149C0332R	WASHER
12	2	NAS1149C0432R	WASHER

*WLB
66532*

RELEASED
 2010-07-16
mp

B		MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); REASON: SEE TR-D350-807-2 REV. B.		MB	10.07.05
A		NEW ISSUE		MB	10.06.18
REV.	DESCRIPTION			BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN	DRAWING NO. D4149			REV. B	
CHECKED				SHEET 1 OF 5	
MFG. APPR.	TITLE			SCALE	
APPROVED	AFT X-TUBE LUG ASSY			NTS	
DE APPR.					
DATE	10.07.05			COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

C

B

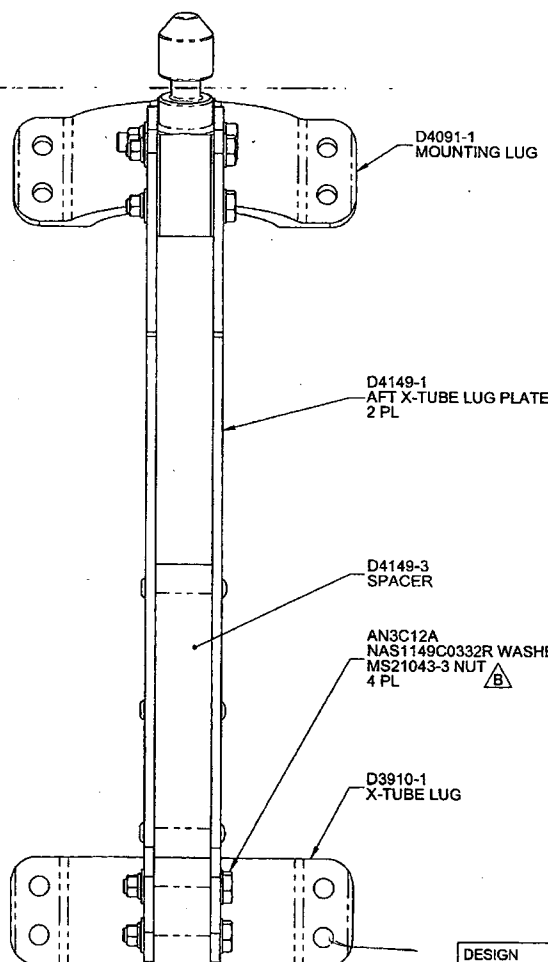
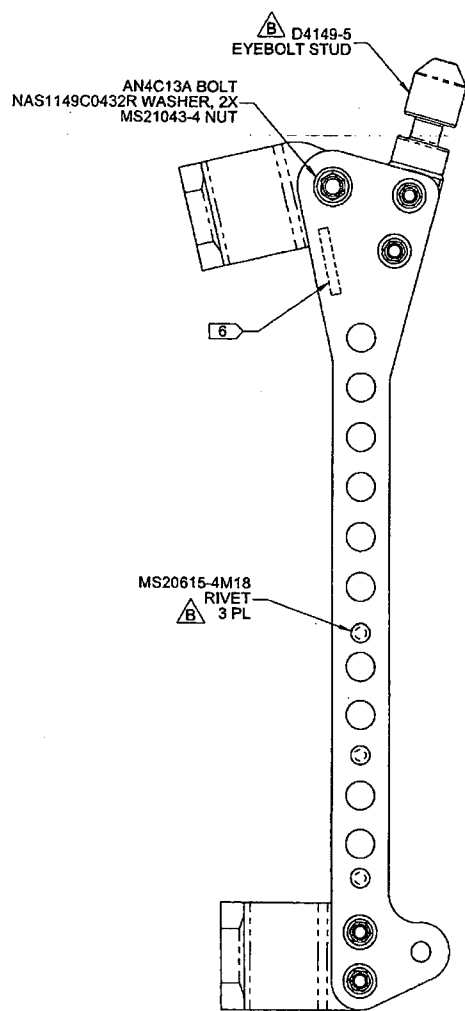
A

D

C

B

A



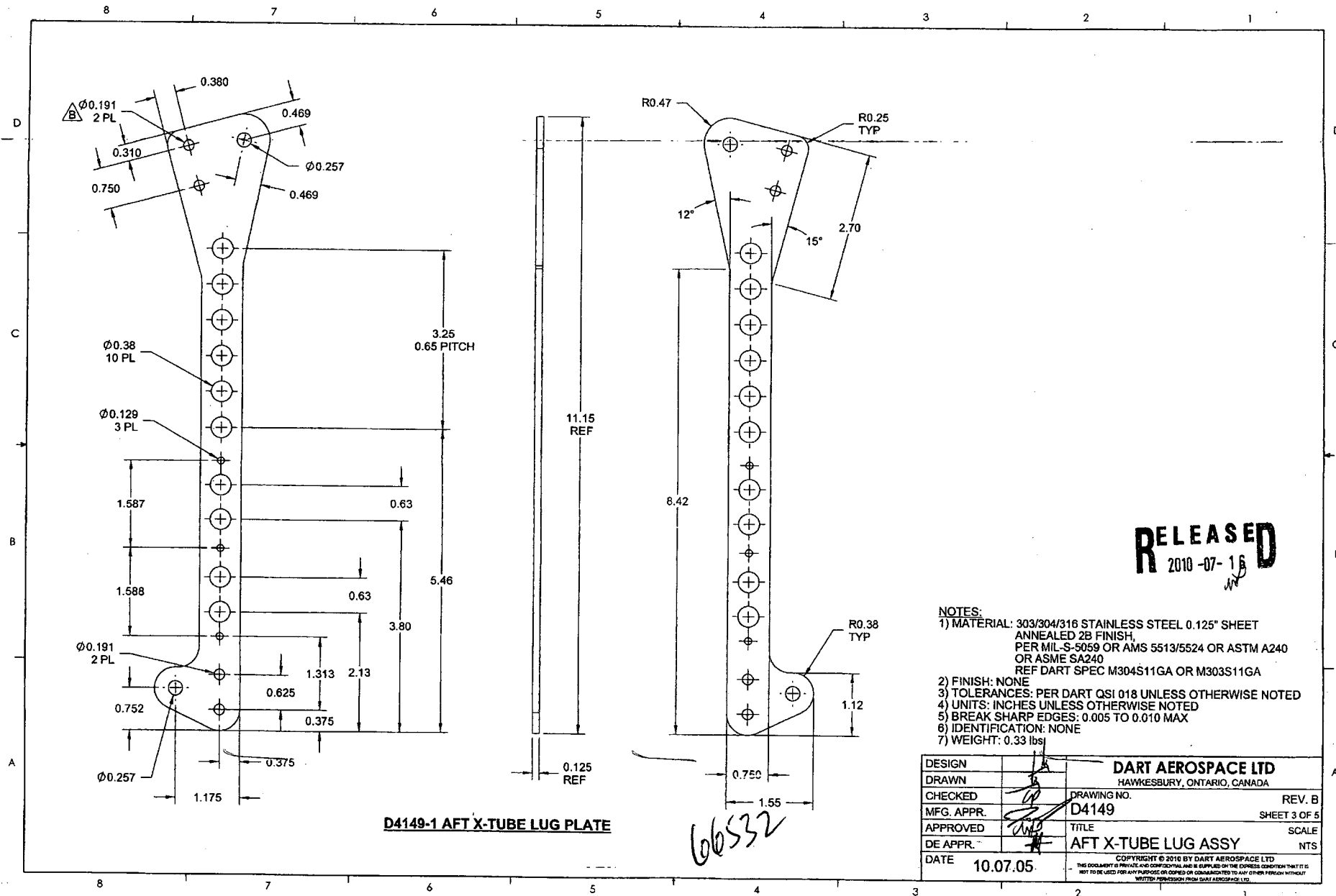
D4149-041 AFT X-TUBE LUG ASSY

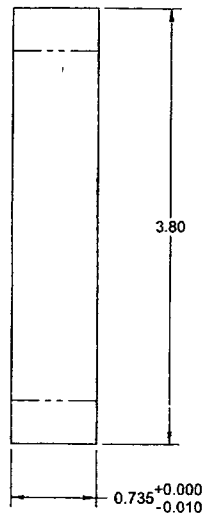
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DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4149
MFG. APPR.		REV. B
APPROVED		SHEET 2 OF 5
DE APPR.		TITLE AFT X-TUBE LUG ASSY
DATE	10.07.05	SCALE NTS
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8 7 6 5 4 3 2 1



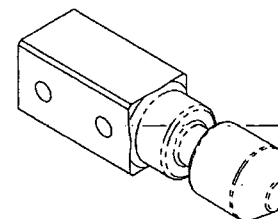
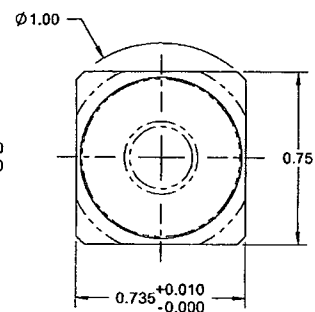
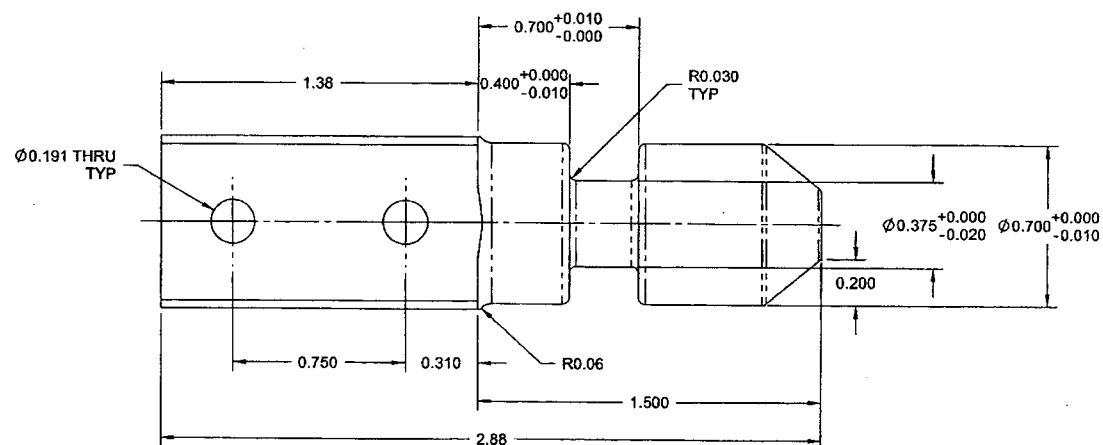


RELEASED
2010-07-16
MM

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

66532

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4149 REV. B SHEET 4 OF 5 TITLE AFT X-TUBE LUG ASSY SCALE NTS
DRAWING		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
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D4149-5 EYEBOLT STUD

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.33 lbs

66532

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4149	REV. B
MFG. APPR.			SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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